

Date: Wednesday, 3/26/2008 2:13:31 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LOW PROFILE BASKET LID ASS'Y  
 Job Number : 38218  
 Estimate Number : 13153  
 P.O. Number :  
 This Issue : 3/26/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3713042  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3713 REVB  
 Drawing Revision : B  
 Previous Run : 37899 Material :  
 Due Date : 4/16/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JD 08.3.27  
 Comment : Est Rev:A new issue 08-01-30 DD verified  
 by:EC  
 Est Rev:B change to revB ecn 1145 08-03-19 DD verified  
 by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 32.5731 f(s)/Unit Total : 32.5731 f(s)  
 304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3714-1	<u>M107514</u>
2	D3715-1	<u>M107514</u>
10	D3716-1	<u>M107514</u>
4	D3732-1	<u>M107514</u>

2- Deburr

AS 08/03/31

2.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Spacer Bushing  
 batch 336920

Pl 08.03.31

3.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Mounting Bracket  
 batch 337248

Pl 08.03.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 2:13:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 38218

Part Number: D3713042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37491

HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch ~~835286~~ B37202

*Pl 08-03-31*

5.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate

batch B35686

*Pl 09-03-31*

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- drill holes in both D3715-1 as per dwg D3715

2- deburr

3- assemble as per dwg D3713 and weld as per QSI004

*Pl 08-04-02*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number

Description

Batch

17sq.ft M304EX0.75-16F

Expanded Metal

M107511

*Pl 08-04-02*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh as per dwg D3743

2- weld mesh as per dwg D3713

*Pl 08-04-02*  
*08/04/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 2:13:31 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 38218

Part Number: D3713042

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP

*2004.07 ①*

Comment: INSPECT WORK TO CURRENT STEP

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-04-07 ①*

11.0

POWDER COATING

POWDER COATING

*M 100700**②*

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*BR 08-04-08*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 08/04/08 ①*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

*m 107385*

Comment: Wing Walk as per Dwg D3713 and QSI 005 4.4

*FL 08/04/08 ①*

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ml 08/04/09*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA**ml 08/04/09*

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/04/10*

Job Completion

*W mf 08-04-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

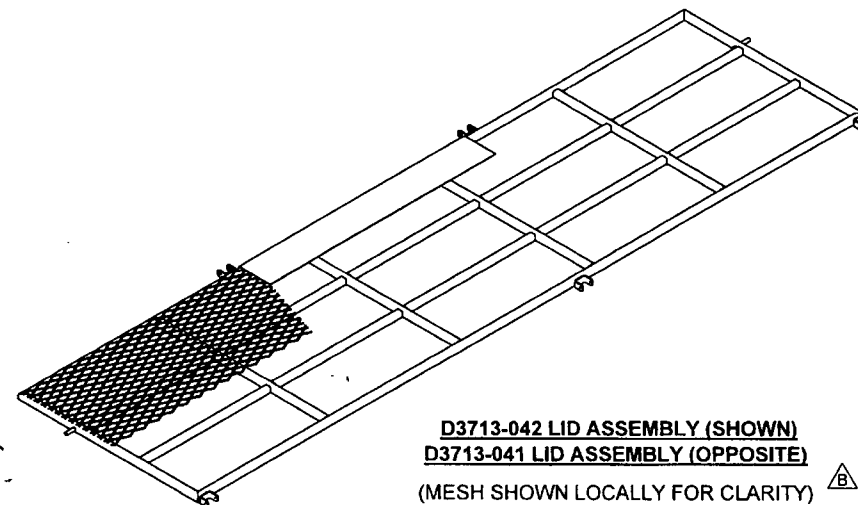
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF







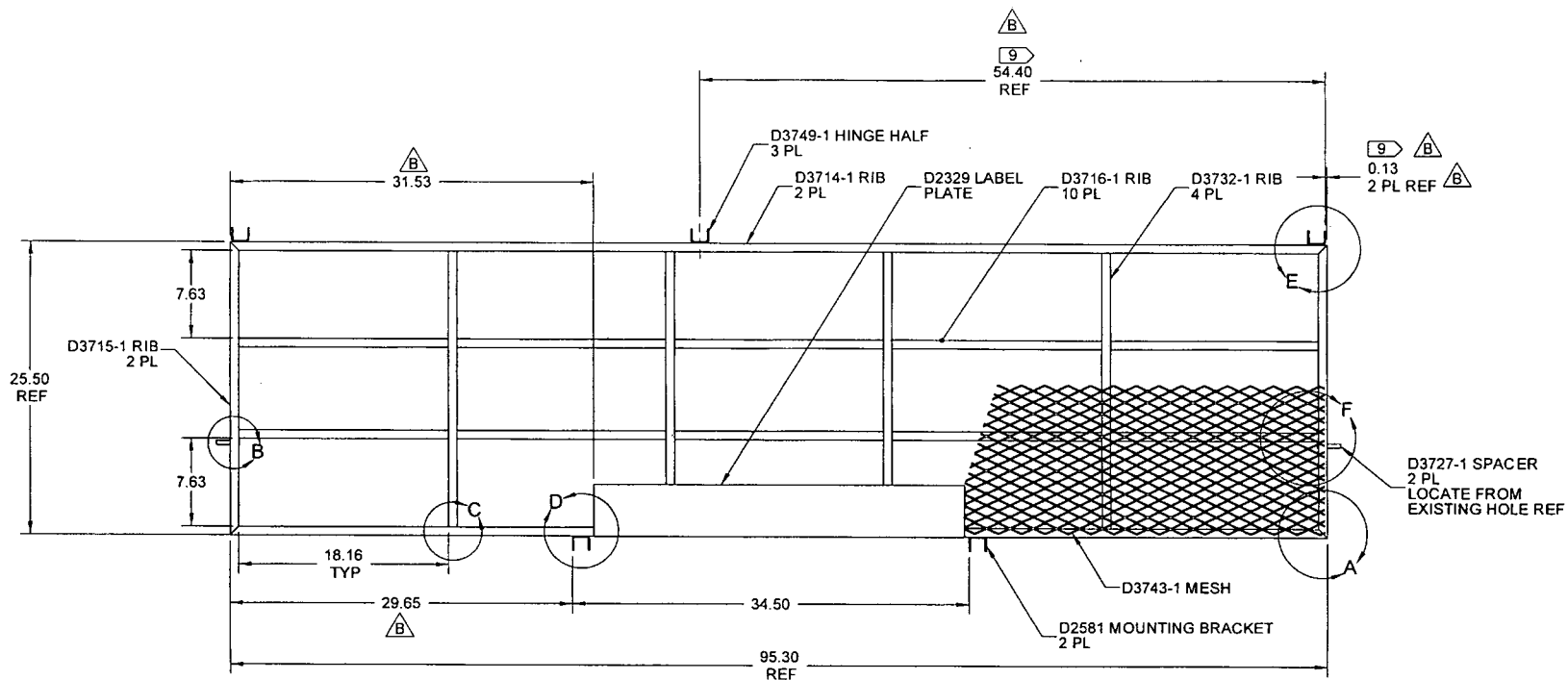
**D3713-042 LID ASSEMBLY (SHOWN)**  
**D3713-041 LID ASSEMBLY (OPPOSITE)**  
 (MESH SHOWN LOCALLY FOR CLARITY)

NO. 138218  
 WORK ORDER  
 SUBJECT TO NOTICE  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
 APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

B	SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY. NOTE 9 ADDED. ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 36 lbs. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041. ZONE D6 31.53 DIM WAS 31.64. ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.77. ZONE D3 & D2 FLAG NOTE 9 ADDED.		AJS	08.02.27
A	NEW ISSUE		AJS	08.02.01
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3713</b>  TITLE <b>LID ASSEMBLY</b>	REV. <b>1</b> OF <b>1</b>  SCALE <b>NTS</b>  COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.02.27			

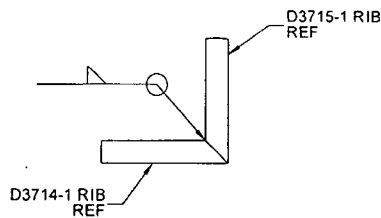


**D3713-042 LID ASSEMBLY (SHOWN) B**  
**D3713-041 LID ASSEMBLY (OPPOSITE)**  
 (MESH SHOWN LOCALLY FOR CLARITY)

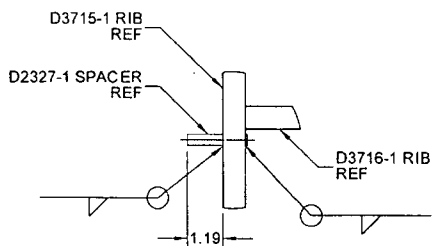
SHOP COPY  
 RETURN TO  
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 WITHOUT NOTICE  
 WORK ORDER  
 NO. 38218

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
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CHECKED	HE	DRAWING NO. D3713	REV. B
MFG. APPR.	MP	TITLE	SHEET 2 OF 3
APPROVED	MP	LID ASSEMBLY	SCALE
DE APPR.	MP		NTS
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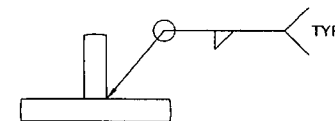




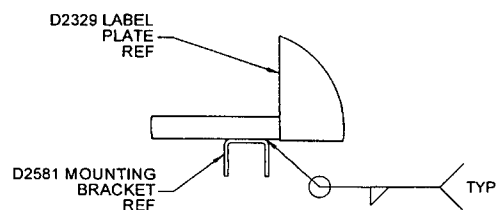
**DETAIL A: TYP CORNER WELDS**  
SCALE 4X  
(MESH NOT SHOWN FOR CLARITY)



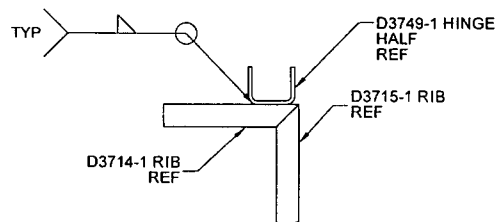
**DETAIL B**  
TYP BOTH ENDS  
SCALE 4X



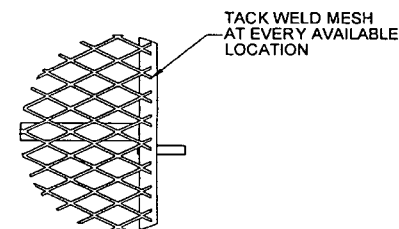
**DETAIL C**  
TYP  
SCALE 4X



**DETAIL D**  
SCALE 4X



**DETAIL E**  
SCALE 4X



**DETAIL F**  
SCALE 5X

NO. 38215  
WORK ORDER  
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MFG. APPR.	ME	D3713	SHEET 3 OF 3
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8 7 6 5 4 3 2 1

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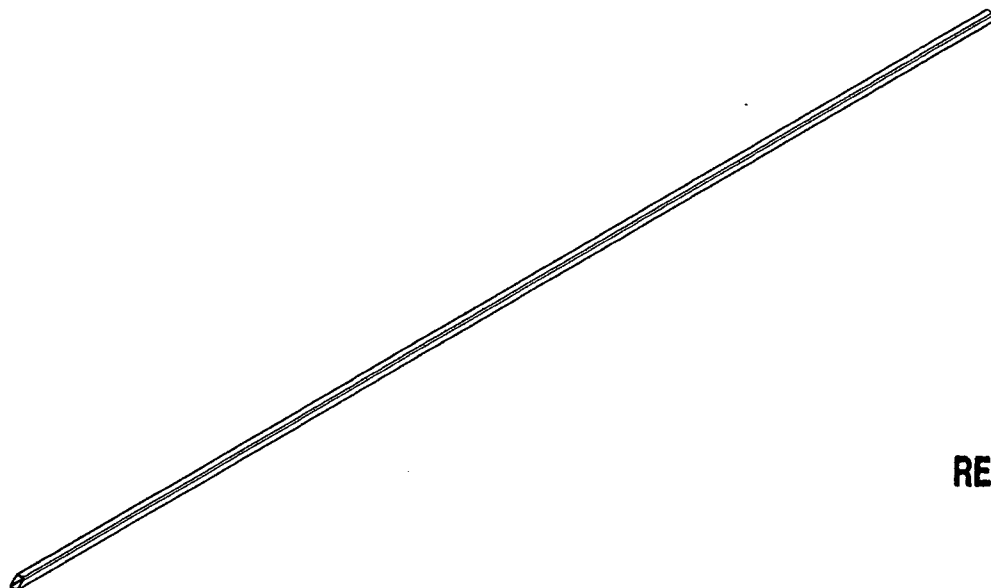
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D3714-1 RIB

REFERENCE ONLY

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08.02.01

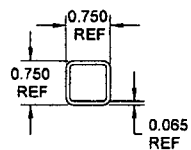
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.54 lbs

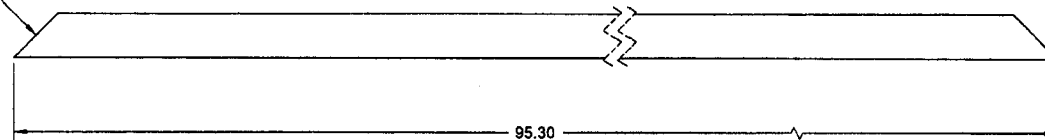
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REV.	DESCRIPTION		BY DATE
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DRAWN	MJS	DRAWING NO.	REV. A
CHECKED	MJS	D3714	SHEET 1 OF 2
MFG. APPR.	MJS	TITLE	SCALE
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DATE	08.02.01		

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8 7 6 5 4 3 2 1



0.75 X 46" CMF  
2PL

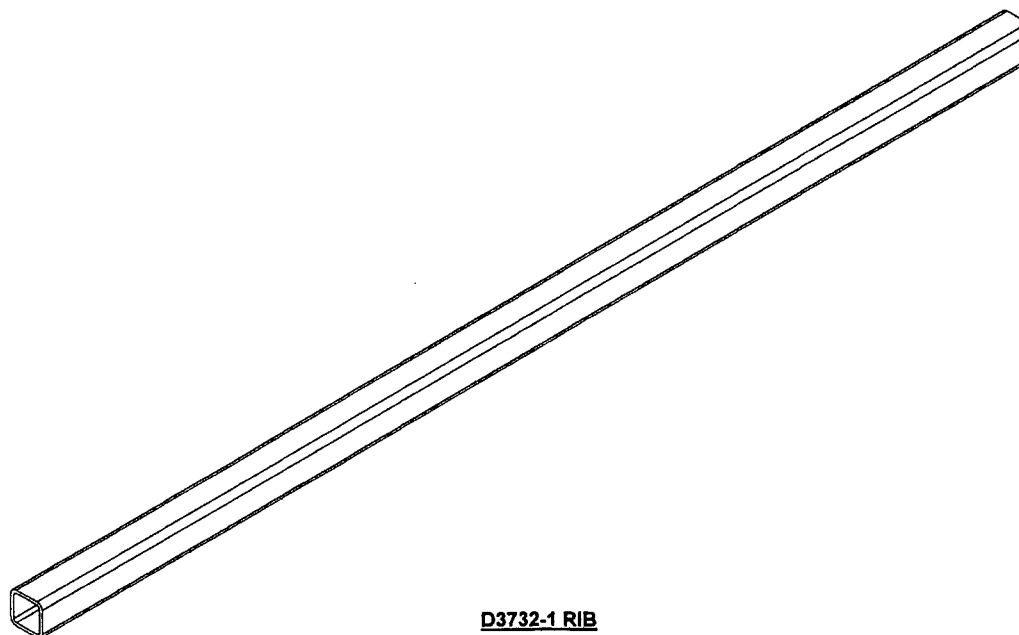


**D3714-1 RIB**

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DRAWN	ASS		
CHECKED	KE	DRAWING NO.	REV. A
MFG. APPR.	AP	D3714	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	RIB	1:2
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**D3732-1 RIB**

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16 08-02-25

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.15 lbs

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	le	DRAWING NO.	REV. A
CHECKED	le	D3732	SHEET 1 OF 2
MFG. APPR.	le	TITLE	SCALE
APPROVED	le	RIB	NTS
DE APPR.	le		
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8 7 6 5 4 3 2 1

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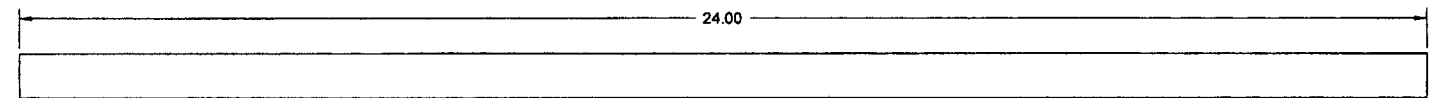
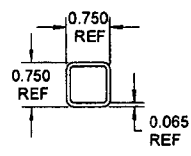
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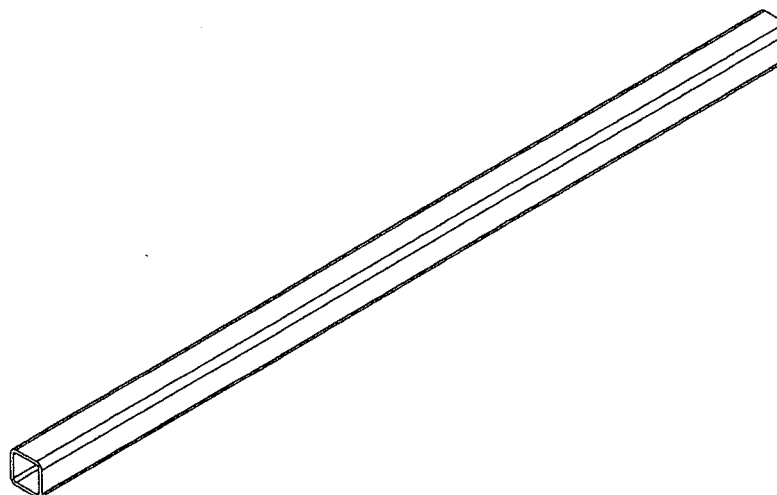
D3732-1 RIB

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11/15/00  
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CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	MP	D3732	SHEET 2 OF 2
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8 7 6 5 4 3 2 1



**D3716-1 RIB**

**REFERENCE ONLY**

RELEASED  
REV. 08.02.25

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.87 lbs

A	NEW ISSUE		AJS	08.02.01
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	ME	DRAWING NO.	REV. A	
MFG. APPR.	ME	D3716	SHEET 1 OF 2	
APPROVED	ME	TITLE	SCALE	
DE APPR.	ME	RIB	NTS	
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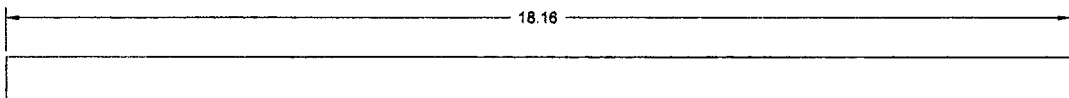
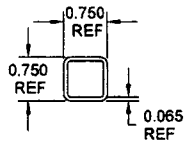
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D3716-1 RIB

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16 08.02.01

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
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CHECKED	LC	DRAWING NO.	REV. A
MFG. APPR.	WJ	D3716	SHEET 2 OF 2
APPROVED	WJ	TITLE	SCALE
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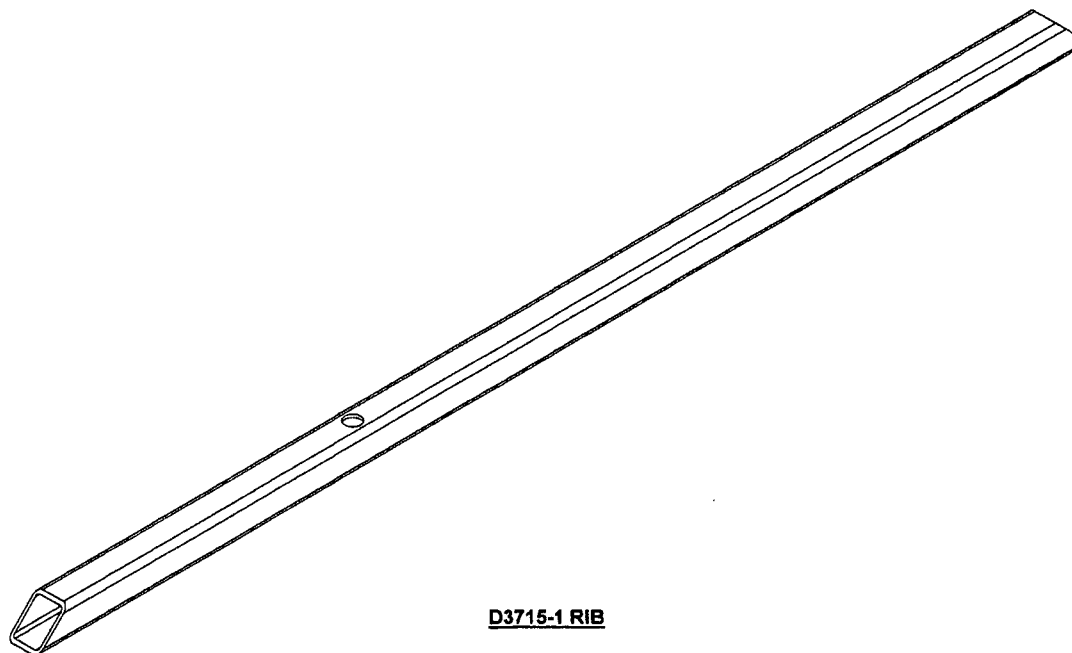
5

4

3

2

1



**D3715-1 RIB**

**REFERENCE ONLY**

**RELEASED**  
08.02.01

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	DP	D3715	SHEET 1 OF 2
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	RIB	NTS
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8 7 6 5 4 3 2 1

D D

C C

B B

A A

0.75 X 45° CMF  
2 PL

25.50

0.750  
REF  
0.750  
REF  
0.085  
REF

Ø0.375  
THRU

0.38

8.00

D3715-1 RIB

REFERENCE ONLY

RELEASED  
16 08.02.01

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ME	DRAWING NO.	REV. A
MFG. APPR.	ME	D3715	SHEET 2 OF 2
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